Wednesday, 4/19/2006 7:36:48 AM

Date: User:

Kim Johnston

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 26706 : 10225 **Estimate Number**

:NIA P.O. Number This Issue

: 4/19/2006 : NC

S.O. No. : N/A

: NIA : 25155

Type

: MACHINED PARTS

Re-format (mpp 2101) EC

Part Number Drawing Number

Drawing Name

: D2150 : D2150 REV. A

: PACKER

: N/A Project Number **Drawing Revision** :NIA Material

Due Date

: 5/5/2006

Qty: 25 Um: Each

Comment **Additional Product**

Checked & Approved By

Prsht Rev.

First Issue

Written By

Previous Run

Job Number:



: Est C 00(.11/.27

Seq. #:

Machine Or Operation:

Description:

M2024T3S040 1.0

2024-T3 .040 sheet

Comment: Qty.: 0.0263 sf(s)/Unit Total:

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: <u>419295</u>

2.0



SHEAR



Comment: SHEAF

Cut blank: 2.300" x 1.559"

+/-0.005"

3.0



Prog Rev. A

Comment: HAAS CNC VERTICAL MACHINING #1

HAAS CNC VERTICAL MACHINING #1



Cut as Machine as per Eolio EA109 and Dwg D2150

Identify as D2150

INSPECT PARTS AS THEY COME OFF MACHINI

4:0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



25

Comment: SECOND CHECK



Dart Aerospace Ltd

W/O:	***	WORK ORDER CH	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #: Fault Category:	NCR: Yes	No) DQ	A: >	P Date: ⊘	16/05/18				

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: <u>06/05//8</u>
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC	Corrective Action Section B			of NC Corrective Action Section B		Description of NC		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
					0.							
						,						

NOTE: Date & initial all entries

	dnesday, 4/19/2006 7:36:48 AM	
User: Kim	Johnston	Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: PACKER
	00700	P0450
Job Number:	26706	Part Number: D2150
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comme	ent: SMALL & MEDIUM FAB RESOURCE 1	
7.0	Deburr HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	HAND FINISHING I	HAND FINISHING RESOURCE #1
Comme	ent: HAND FINISHING RESOURCE #1	
	Chemical Conversion Coat as per QSI 00	
8.0	POWDER COATING	POWDER COATING
Comme	ent: POWDER COATING	
	Powder Coat White Gloss (Ref: 4.3.5.1) a	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	QC3	INSPECT POWDER COAT/CHEINICAL CONVERSION
	nt: INSPECT POWDER COAT	(44/0/17 (20)
10.0	PACKAGING 1	PACKAGING RESOURCE#1
Comme	nt: PACKAGING RESOURCE #1	
	Identify and Stock Location: S726	(ec/s/1 (20)
11.0	DC	DOCUMENT CONTRÔL , , ,
Comme	nt: DOCUMENT CONTROL	(1) (25)
	Inspection Level 21	06/05/18
Job Completion		U D6.05.18

Dart Aerospace Ltd

W /O:		WORK ORDER CH	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC	Description of NC Corrective Action			Manifi andi an				
		Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng	ai Approval QC Inspector			
						,				
					_					
	-									
		•			,					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26706
Description: Packer	Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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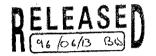
Drawing	Tolerance	Actual Accept Reject		Reject	Method of	Comments
Dimension	lolerance	Dimension	Accept Reject		Inspection	Comments
0.740	+/-0.010	0.746	<i></i>			
2.050	+/-0.010	2.054				
0.231	+/-0.010	0,223				
1.217	+/-0.010	1.216	/			
1.559 [/]	+/-0.010	1.5655				
2.300	+/-0.010	2-36-752	302 ~			
1.560	+/-0.010	1.5635	~			
0.250	+/-0.010	0,255	/			
1.328	+/-0.010	1.337	<u></u>			
0.342	+/-0.010	0.345	<u> </u>			
Ø0.098	+0.005/-0.000	Ø.100	/			
Ø0.171	+0.005/-0.000	Ø.172	_			
0.040	+/-0.010	0.6395		·		

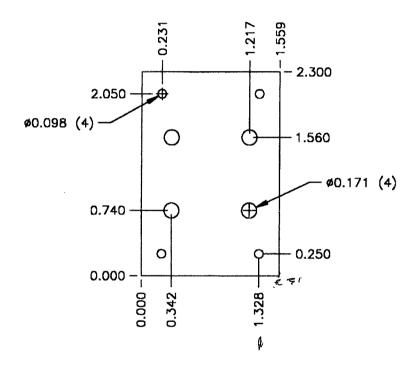
Measured by:	SAL	Audited by:	a	Prototype Approval:	N/A
Date:	66:05:10	Date:	06-05,10	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	Α	04.09.28	New Issue	KJ/JLM 🛠	
_					$\overline{}$



DESIGN B WILLIAMS	DRAWN BY		AEROSPACE LTD ERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
Bu	Bu	D2150	SHEET 1 OF 1
DATE		TILE	SCALE
95:05:01		PACKER	1:1





SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

MATERIAL: 2024-T3, 0.040 THICK

FINISH: WHITE POWDER COAT HI-GLOSS

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